

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002569**Date Inspected:** 22-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG Deck Panels		

**Summary of Items Observed:**

Caltrans Quality Assurance Inspector Mr. David Kelsey (Caltrans QA Inspector) arrived at Shanghai Zhenhua Port Machinery Co (ZPMC) to observe the ZPMC Quality Control Inspectors noted below perform the duties and responsibilities as outlined in the Welding Quality Control Plan (WQCP), Contract Special Provisions and to randomly inspect the in-process welding fabrication at ZPMC fabrication facility for the Orthotropic Box Girder (OBG) and Tower bridge structural components

CWI Inspector: NA No welding observed.

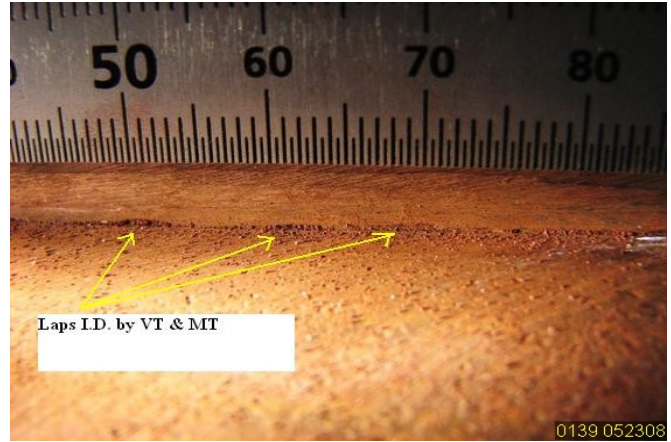
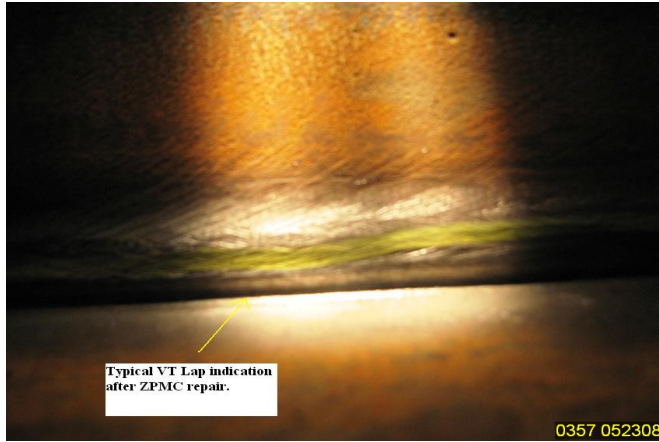
This Caltrans QA Inspector Mr. David Kelsey performed Final Visual Testing (VT) on DP017-001; DP058-001 & DP059-001 partial penetration repair welds 001 thru 010. This inspector marked and measured numerous visual indications of the ZPMC repaired areas such as laps in the weld toes adjacent to the deck panel. This inspector was not able to finish marking all the numerous indications in the ZPMC repaired areas or record the results and Y locations on the deck panel inspection form before shift end time. This inspector also performed informational MT of the visually identified lap indications and was also found to be non-compliant per welding code AWS D1.5 2002 paragraph 6.26.1.2 & 6.26.2. No other observation took place during the shift by this inspector. See reference pictures below of previously mentioned weld lap indications.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

Some Deck panels were stacked and were inaccessible, others deck panels the welds had rust scale on them preventing this inspector from carrying out VT or MT. ZPMC lead night shift Quality Control Inspector Mr. Wang Hu Testino stated that that he had no crane operators to shake out the deck panels. The QC Inspector did provide some personnel for a limited time to power brush some of rust scale off the affected welds but was unable to finish before the workers shift came to an end. This QA Inspector noted that ZPMC Quality Control Inspector Mr. Wang Hu Testino was very courteous and helpful with our previously mentioned request with the limited resources he had at his disposal.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Kelsey,David

Quality Assurance Inspector

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**Reviewed By:** Cochran,Jim

QA Reviewer